

Date: Monday, 1/7/2008 3:38:09 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CROSSTUBE	
Job Number	: 36621		Part Number	: D2890	
Estimate Number	: 10377		Drawing Number	: D2890 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/7/2008 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/14/2008	
Previous Run	: 36620		Qty:	1	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	: Est. 05.03.21		Removed Bending procedures KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6008180	Crosstube extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part # Description Batch 1 D6008-180 Crosstube extrusion 023967		
2.0	BENDING	BENDING MACHINE
Comment: BENDING MACHINE 1-Bend D2890 as per Dwg D2890 and Folio FT002		
3.0	QC6	DIMENSIONAL CHECK
		 <i>1/7/08 01.11</i>
Comment: DIMENSIONAL CHECK		
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 <i>N/A</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: HD Date: 08/01/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 36621

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W10 36471

(-107)

08-01-11

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-01-14

Job Completion



08-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 36621

Description: Crosstube Aft

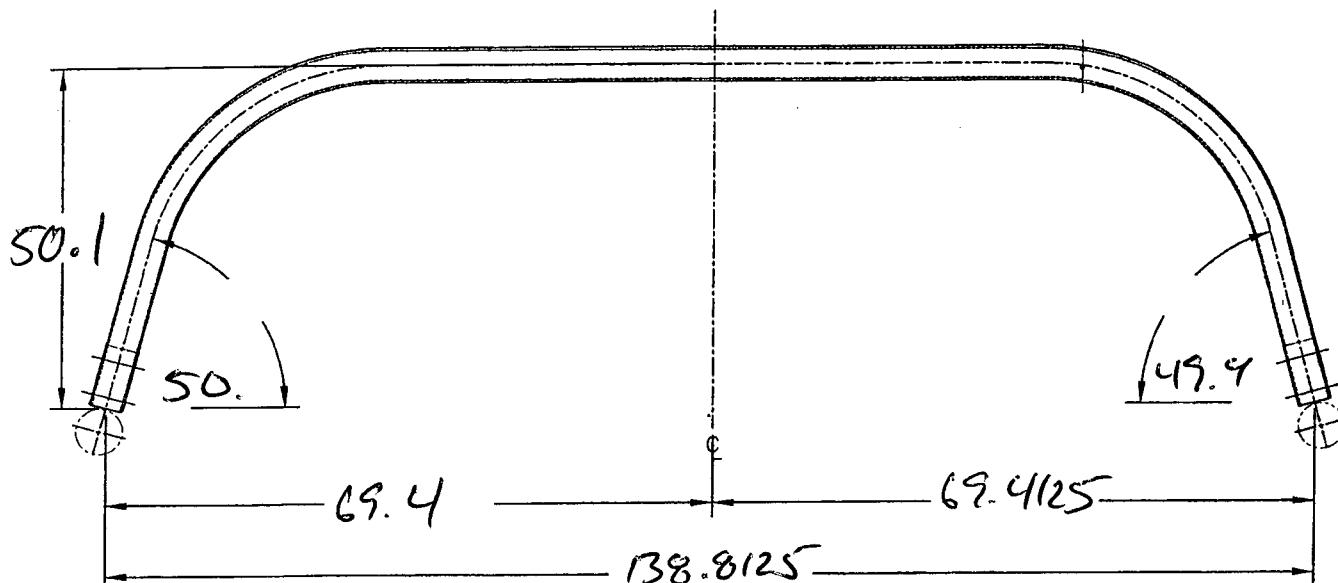
Part Number: D2890

Inspection Dwg: D2890

Rev: B

Page 1 of 1

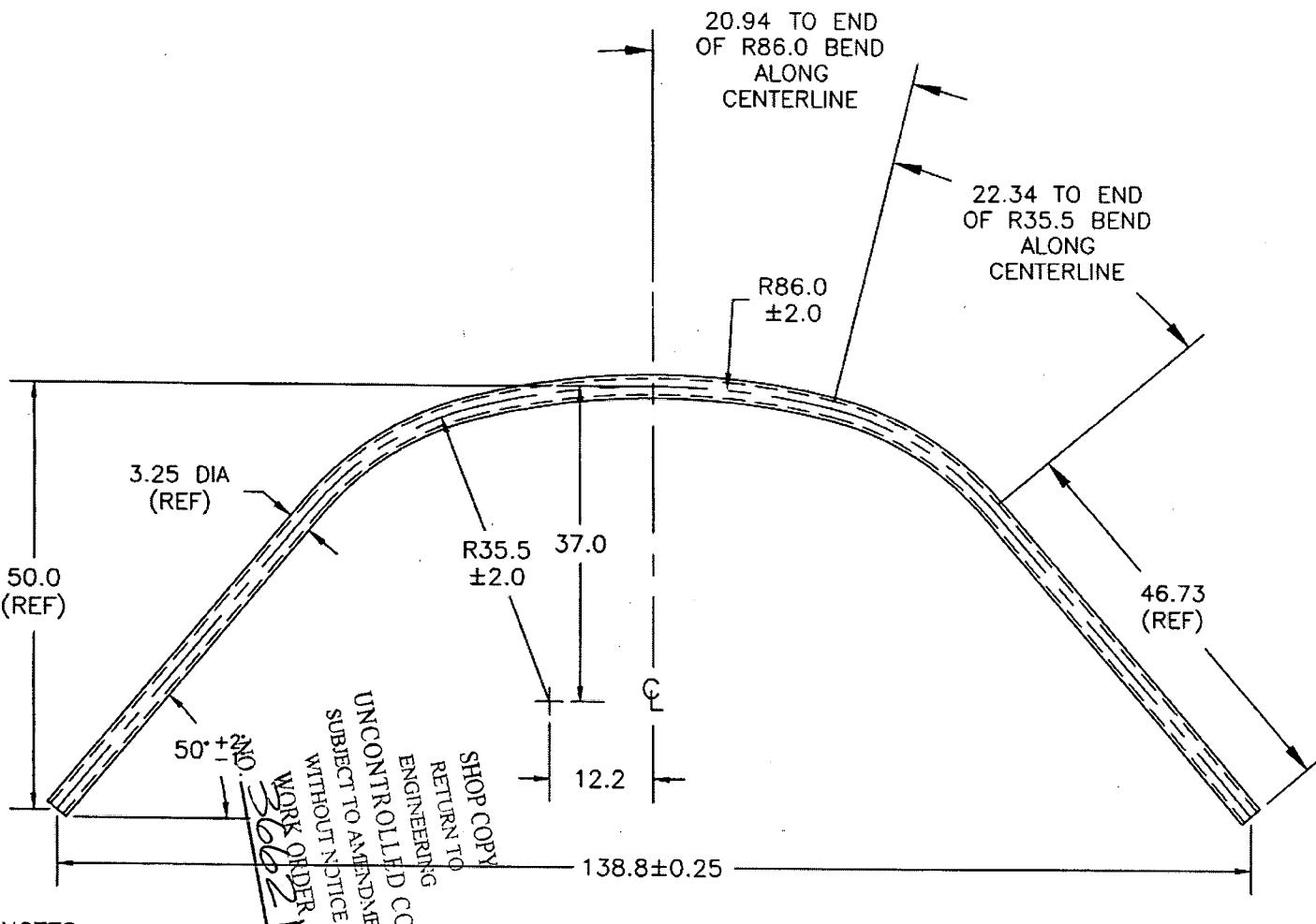
Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

QC15 Inspection	<i>✓</i>
Date	08.01.11

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>✓</i>	<i>✓</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2890	SHEET 1 OF 1
DATE	TITLE	SCALE	
02.10.18	AFT CROSSTUBE	1:20	
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	

DAFT
02.10.28

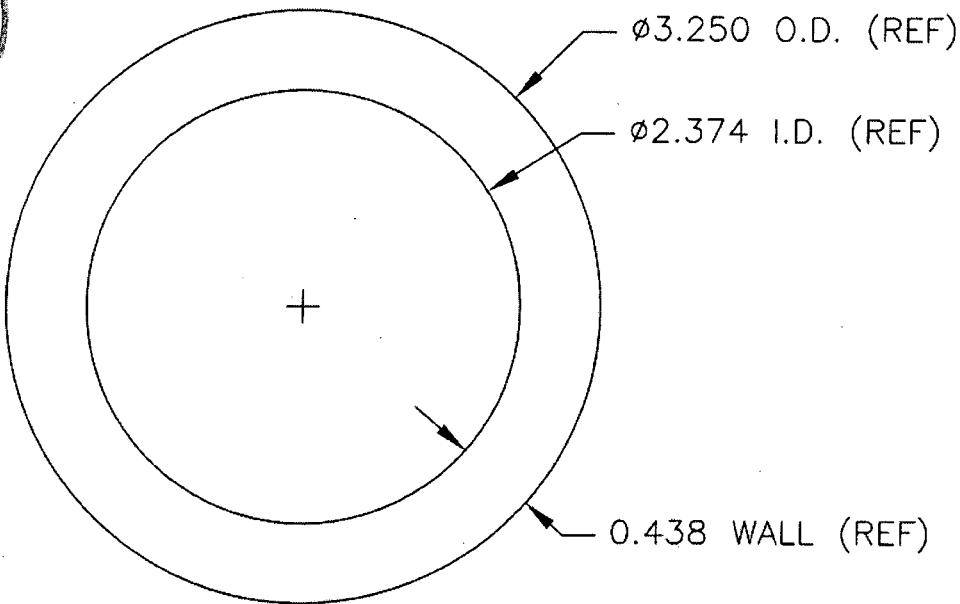
DAFT
02.10.28



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008 REV. A SHEET 1 OF 1
DATE		SCALE 1:1
00.11.17		TITLE CROSSTUBE MATERIAL
A	00.11.17	NEW ISSUE

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24



NOTES

1) D6008-XXX CROSSTUBE
[]
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008-180

2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHOB COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36621